

**Work Order ID 64293**

Wednesday, December 01, 2010 1:22:04 PM

Page 1

Item ID: D3836-042

Accept

Setup Start

Revision ID:

Stop

Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 12/1/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 12/8/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-12-1

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3836

Rev A

100

0.00



Large Fab

Large Fab

**Memo**

0.00

Large Fab

1- cut D3836-2 and D3836-3 rib as per dwg D3836

2- remove identification markings

3- deburr

4- weld D3836-2 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836

5- weld D2327-3 spacer bushing as per dwg D3836

A/R ER316 S.S. Rod Batch: M111585

6- grind weld flush where indicated on dwg

SAD 10-12-02

LPL 10-12-07

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



**NOTE:** Date & initial all entries




# Work Order ID 64293

Wednesday, December 01, 2010 1:22:04 PM

Page 2

Item ID:	D3836-042	Accept		Setup	Start	
Pevision ID:						
Item Name:	Rib Assembly (Basket Lid, RH)				Stop	
Start Date:	12/1/2010	Start Qty: 2.00		Cust Item ID:		
Required Date:	12/8/2010	Req'd Qty: 2.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00  0.00				2	2	BE10/12/07	
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				(+2)			
150  Packaging Packaging	Identify as per dwg & Stock Location: <i>WA</i>  Memo	0.00  0.00							

*10.12.08*

*Swirloe*

*SAD  
10-12-08*

*(+2)  
-042*

*(2)*

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 64293**

Page 3

Wednesday, December 01, 2010 1:22:04 PM

Item ID: D3836-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 12/1/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/8/2010 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/09 *[Signature]**MF*  
10-12-08

W/O:		WORK ORDER CHANGES					
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, December 01, 2010 1:22:09 PM

Page 1

Work Order ID: 64293

Parent Item: D3836-042

Parent Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 12/1/2010

Required Date: 12/8/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:eC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2327-3 Spacer Bushing		Manufactured	No			100	Each	25.0000	1				

*2*  
*Cpl 10-12-07*

Location	Loc Qty	Loc Code
WA	25	
58974	1	
60320	1	
60952	2	
64048	21	

M304TS0.750W.065

Purchased

No

100

f

1,062.852

1.7808

3.749053



304 SQ Tube .75x.75x.065W

*2*

*SAD 10-12-02*

Location	Loc Qty	Loc Code
MAT	1015.74795	
112398	0	
115494	4.4725	
115593	11.27545	
116267	1000	
WA	47.104485	
115274	4.712185	
115901	42.3923	

*3.7491*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

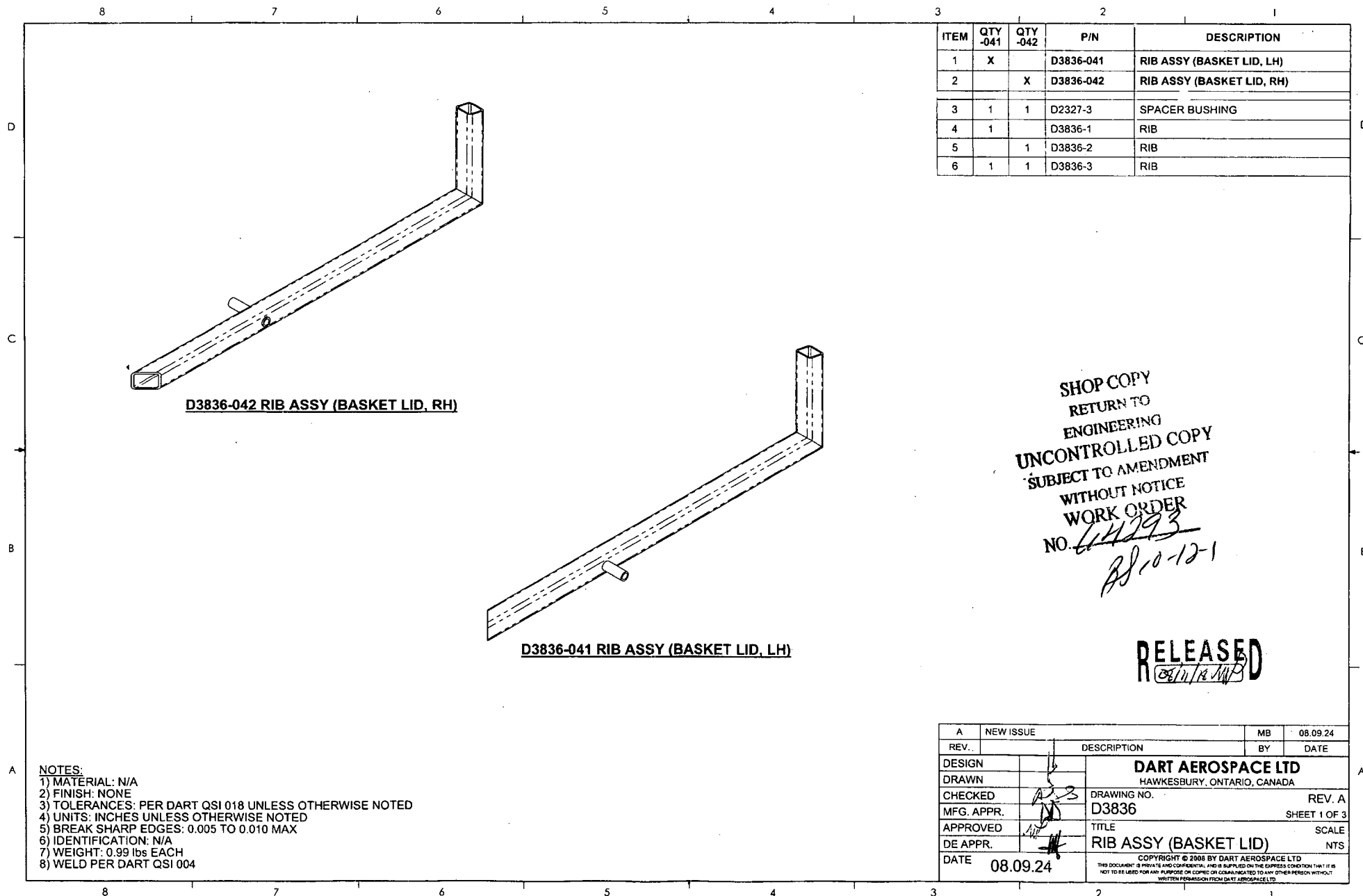
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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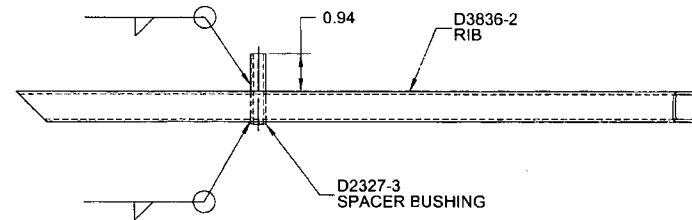
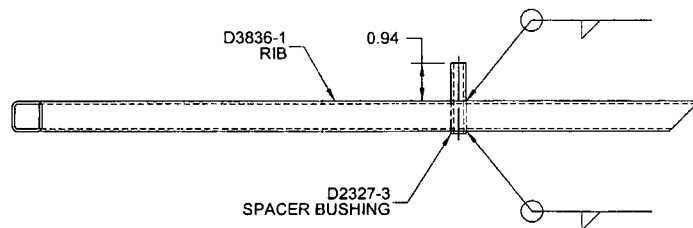
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**NOTE:** Date & initial all entries

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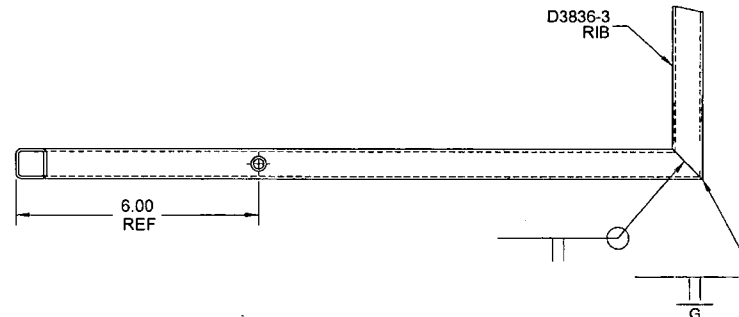
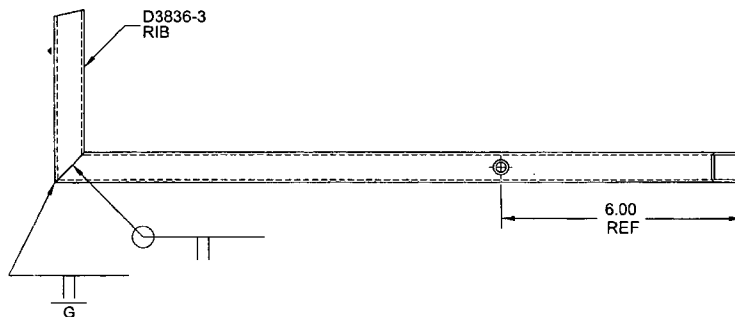
D

D



C

C



B

B

**D3836-041 RIB ASSY (BASKET LID, LH)**

**D3836-042 RIB ASSY (BASKET LID, RH)**

u644293

**RELEASED**  
08/11/18

A

A

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. <b>D3836</b>
MFG. APPR.		REV. A
APPROVED		TITLE <b>RIB ASSY (BASKET LID)</b>
DE APPR.		SCALE <b>NTS</b>
DATE	<b>08.09.24</b>	COPYRIGHT © 2008 BY DART AEROSPACE LTD
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

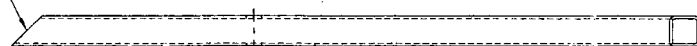
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

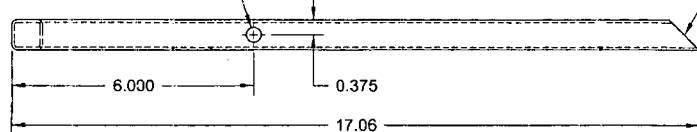
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**NOTE:** Date & initial all entries

0.75 X 45°  
CHAMFER

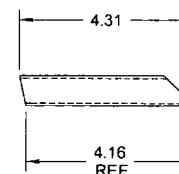


$\varnothing 0.375^{+0.020}_{-0.000}$  THRU



0.75 X 45°  
CHAMFER

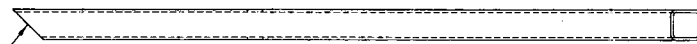
**D3836-1 RIB**



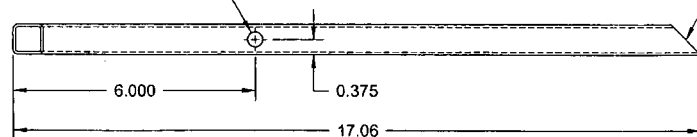
0.75 X 45°  
CHAMFER

**D3836-3 RIB**

0.75 X 45°  
CHAMFER

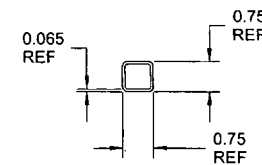


$\varnothing 0.375^{+0.020}_{-0.000}$  THRU



0.75 X 45°  
CHAMFER

**D3836-2 RIB**



**TYPICAL SECTION  
VIEW**

**RELEASED**  
08/11/18

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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